

Work Order ID 62562

Monday, October 04, 2010 1:08:06 PM



Page 1

Item ID: D4092-041

Accept



Setup Start



Revision ID:

Item Name: Maintenance Step Assembly

Stop



Start Date: 10/5/2010 Start Qty: 200

Required Date: 10/19/2010 Req'd Qty: 200



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: mf

Date: 10-10-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4092	A

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--



Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging

110		0.00							
-----	--	------	--	--	--	--	--	--	--



Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
-----------	--	--	--	--	--	--	--	--	--

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

8/10/10/03 to RWA
PM



241



MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Work Order ID 62562

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Page 2

Item ID: D4092-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Maintenance Step Assembly

Start Date: 10/5/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/19/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPS 63105

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.11.18 testonly
- approved devial D4093-562569
- D4092-1 Rev. PBI 63047

10.11.17

Picklist Print

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Page 1

Work Order ID: 62562

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 10/5/2010

Required Date: 10/19/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No			100	Each	0.0000	2	4			
D4093-1 Bracket		Manufactured	No			100	Each	0.0000	1	2			
D4093-3 Bracket		Manufactured	No			100	Each	0.0000	1	2			
D4093-5 Bracket		Manufactured	No			100	Each	0.0000	2	4			
MS24694-S54 Screw		Purchased	No			100	Each	114.0000	2	4			

B63047 (12)

B63825 (12)

EP 10/11/03

62565

62567

62569

M116022

Location

Loc Qty

Loc Code

ST289

114

113359

1

115371

13

115531

100

MS24694-S55

Purchased

No

100

Each

77.0000

8

16

10/11/02 (2)

Location

Loc Qty

Loc Code

ST289A

77

13884

77

13884

Picklist Print

Monday, October 04, 2010 1:08:05 PM

Page 2

Work Order ID: 62562

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 10/5/2010

Required Date: 10/19/2010

Start Qty: 2.00

Required Qty: 2.00

MS24694-S56

Purchased

No

100

Each

110.0000

2

4



SCREW

Location

Loc Qty

Loc Code

ST289A

110

104407

110

NAS1149D0332J

Purchased

No

100

Each

613.0000

12

24



Washer

Location

Loc Qty

Loc Code

ST298

613

110985

14

114348

130

114884

269

114962

200

MS21042L3

Purchased

No

100

Each

2,684.000

12

24



Nut

Location

Loc Qty

Loc Code

ST300

2684

114523

49

114784

1635

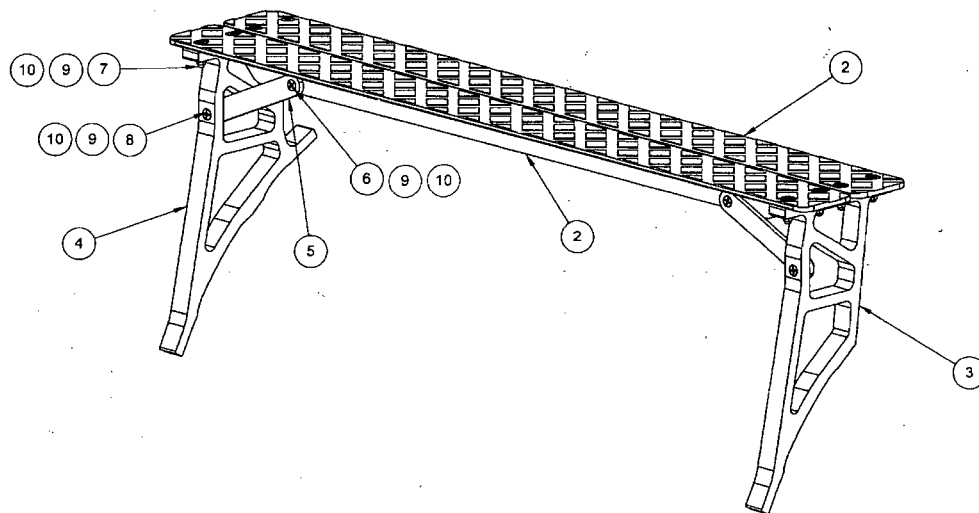
115835

1000

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Shop Packet Print

Page 2



D4092-041 MAINTENANCE STEP ASS'Y

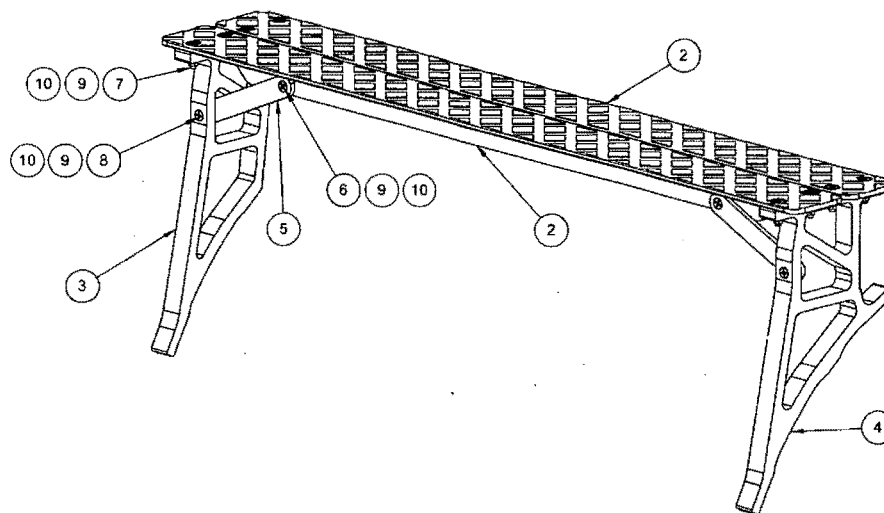
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASS'Y
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT

RELEASED
R 2010-09-23 D

A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4092	SHEET 1 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	10.09.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

D4092-042 MAINTENANCE STEP ASS'Y

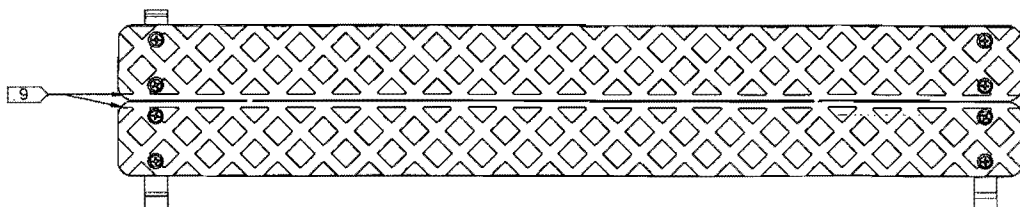
ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASS'Y
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT



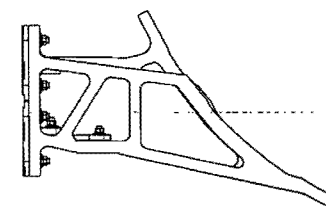
#62502

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D4092-1
MAINTENANCE STEP



D4093-3
BRACKET

8
INSTALL
MS24694-S56 SCREW
NAS1149D0332J WASHER
MS21042L3 NUT
2 PL

8
INSTALL
MS24694-S54 SCREW
NAS1149D0332J WASHER
MS21042L3 NUT
2 PL

D4093-5 BRACE
2 PL

8
INSTALL
MS24694-S55 SCREW
NAS1149D0332J WASHER
MS21042L3 NUT
4 PL PER SIDE

D4093-1
BRACKET

#62562

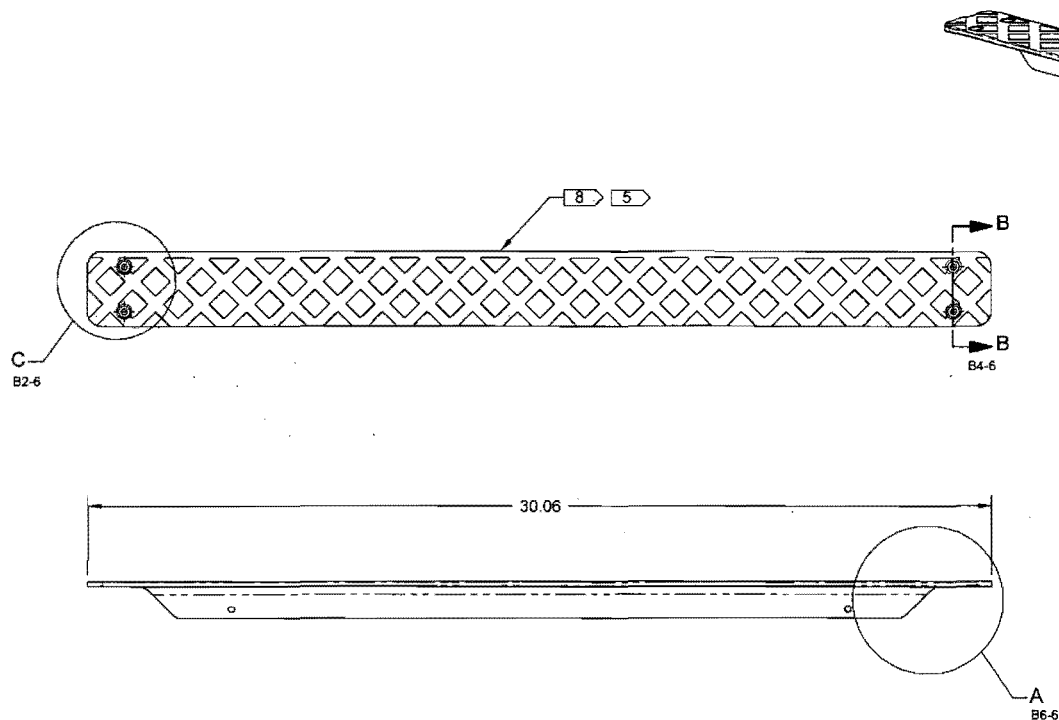
RELEASED
2010-09-23

D4092-041 MAINTENANCE STEP ASS'Y

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 6.01 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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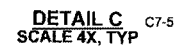
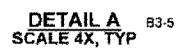
D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

RELEASED
2010-09-23
JND

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK SPOT FACE HOLES PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

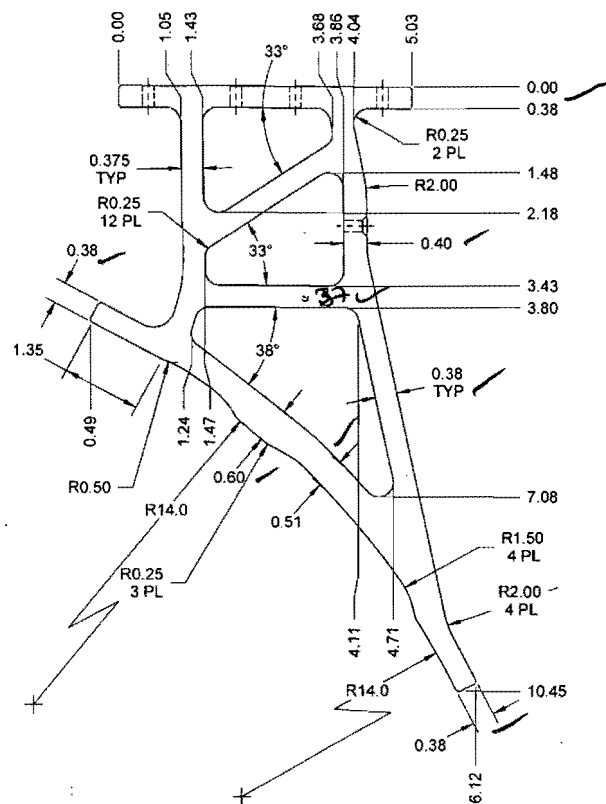
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MFG. APPR.	RF	D4092	SHEET 5 OF 8
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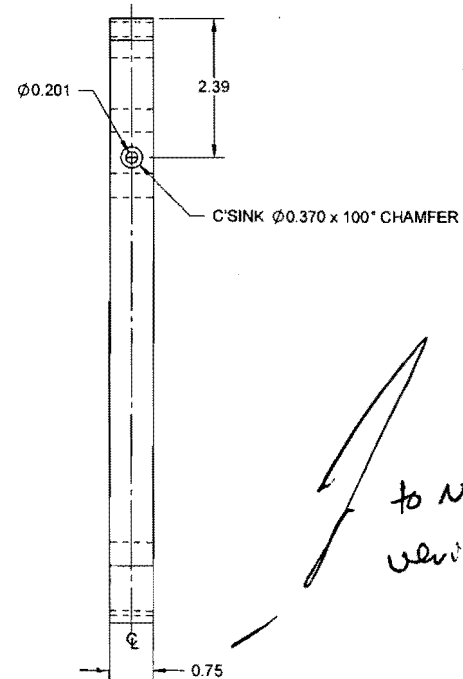
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2010-09-23

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MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASSY	
DATE	10.09.16	NTS	

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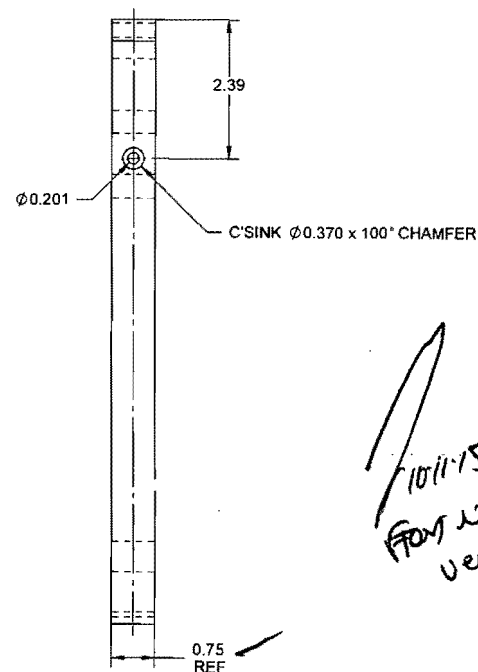
D4093-3 BRACKET



to NCR
verification
10-11-15

RELEASED
2010-09-23
WP

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MFG. APPR.	21	D4093	SHEET 4 OF 5
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DE APPR.	10	BRACKET	NTS
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10/11/15
FROM WCR
Verification

RELEASE
2010-09-23
mp

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CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4093	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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